

Work Order ID 61020

Wednesday, August 04, 2010 9:23:16 AM

Page 1

Item ID: D3508-1

Accept

Revision ID:

Item Name: Wearplate

Start Date: 8/4/2010 Start Qty: 10.00

Required Date: 8/11/2010 Req'd Qty: 10.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: MF Date: 10-8-04 Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3508	Rev C

100 0.00



Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3508 ☐ Dwg Rev: C ☐ Prog Rev: C ☐ 2-
Debur if necessaryR 10-8-5

110 0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

R 10-8-8

120 0.00



QC

QC8- Inspect parts - second check

Memo

0.00

Quality Control

Sokolos

414 Pho →

W/O: 61020		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/08/05	#120	Took qty +1 for qc inspection template	S	10/08/05	x1		S 10/08/05

Part No: D3508-1 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Required Date: 8/11/2010 Req'd Qty: 10.00

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Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Brake NC

Brake NC

NC BRAKE

Memo

Deburr and form on brake using DT8326 and DT8261 as per Dwg D3508

0.00

0.00

SB 10/08/24

(14)

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

S 10/08/24

(14)

150



Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

Memo

START TIME:

3:15

OVEN TEMPERATURE:

3:00 FINISH TIME:

3:45

0.00

0.00

14 BL 10-8-26

W/O:		WORK ORDER CHANGES					
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Work Order ID 61020

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Item ID: D3508-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Wearplate

Start Date: 8/4/2010 Start Qty: 10.00

Cust Item ID:

Required Date: 8/11/2010 Req'd Qty: 10.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00

=> MU 10/08/27

14

Ø



QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location: FP-16

0.00

=> MU 10/08/27

14

Ø



Packaging

Memo

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/08/27 DJ
B/ 10-V-27
(14)

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NOTE: Date & initial all entries

Picklist Print

Wednesday, August 04, 2010 9:23:16 AM

Page 1

Work Order ID: 61020



Parent Item: D3508-1



Parent Item Name: Wearplate



Start Date: 8/4/2010

Required Date: 8/11/2010

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A New Issue 06-06-20 JLM
IPP Rev:B Now SS as per Rev B 06-12-15 JLM
IPP Rev:C Rev C dwg 07-12-06 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA  304/316 .040 Sheet		Purchased	No			100	sf	23.8987	0.237	2.494737	4.3		
											HB10-8-5		

Location

Loc Qty

Loc Code

MAT

20.4522

114574

20.4522

MAT20

3.4465

112885

2.7475

113062

0.699

114574



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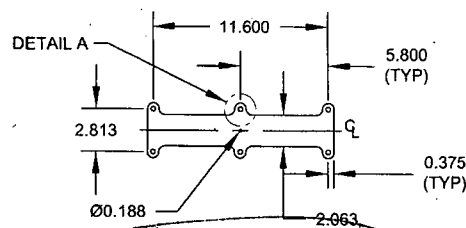
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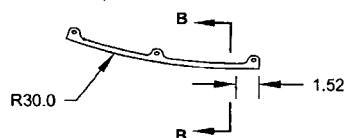
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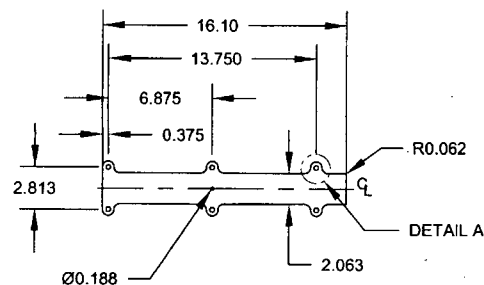
NOTE: Date & initial all entries



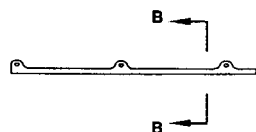
D3508-1 FLAT PATTERN



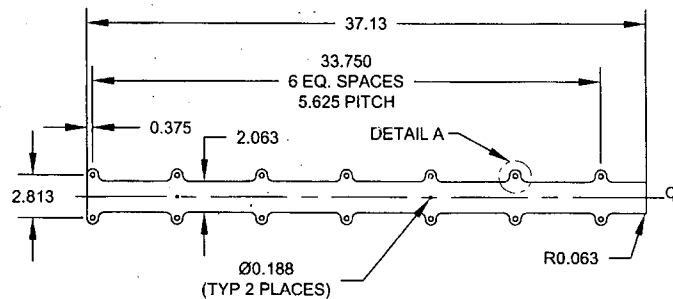
D3508-1 BENDING DETAIL
(MAKE FROM D3508-1F)



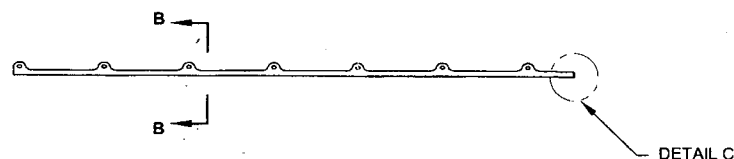
D3508-7F FLAT PATTERN



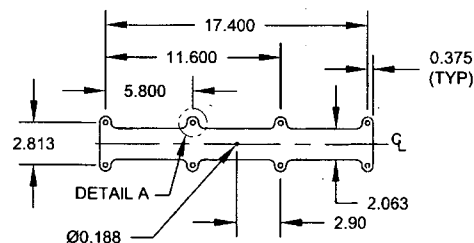
D3508-7F BENDING DETAIL
(MAKE FROM D3508-7F)



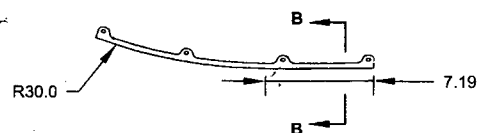
D3508-3 FLAT PATTERN



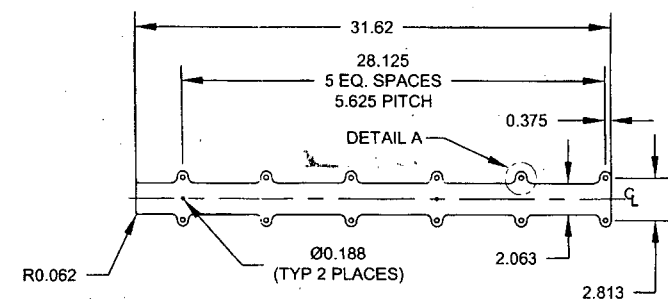
D3508-3 BENDING DETAIL
(MAKE FROM D3508-3F)



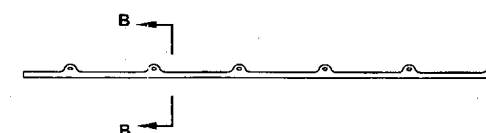
D3508-9F FLAT PATTERN



D3508-9F BENDING DETAIL
(MAKE FROM D3508-9F)



D3508-5 FLAT PATTERN



D3508-5 BENDING DETAIL
(MAKE FROM D3508-5F)

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)
(REF. DART MATERIAL SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.015
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: D3508-1 - 0.47 lbs, D3508-3 - 0.95 lbs, D3508-5 - 0.77 lbs,
D3508-7 - 0.39 lbs, D3508-9 - 0.45 lbs, D3508-11 - 0.64 lbs
D3508-13 - 0.25 lbs

RELEASED
07.11.16

C	ADD -9/-11/-13 MOVE TAB OUTBOARD (2.813 WAS 2.733) CHANGE DRAWING FORMAT	PH	07.04.20
B	CHANGE STAINLESS STEEL, WIDEN	PH	06.10.27
A	NEW ISSUE	PH	06.04.21
REV	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>	DART AEROSPACE USA, INC	
DRAWN	<i>[Signature]</i>	PORT HADLOCK, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3508	SHEET 1 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	WEARPLATE	1:8
DATE	07.04.20	COPYRIGHT © 2007 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

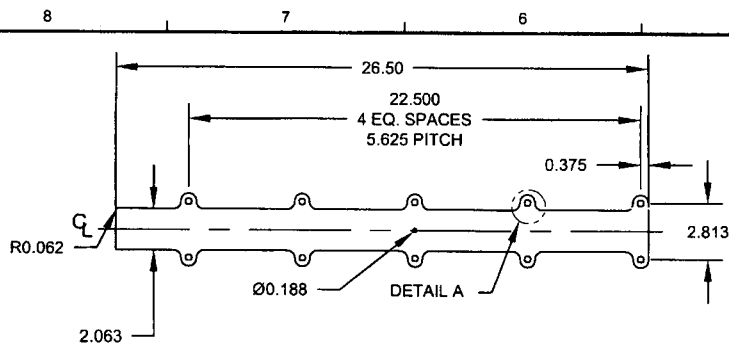
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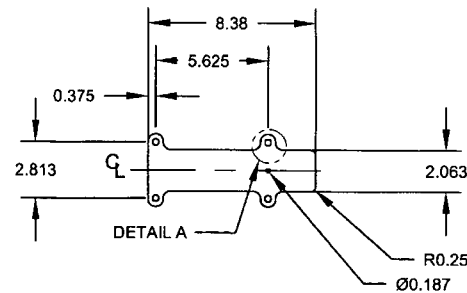
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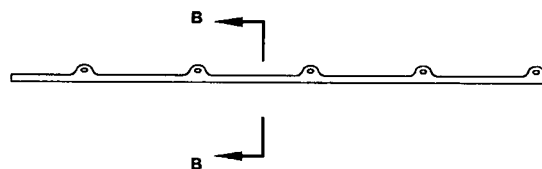
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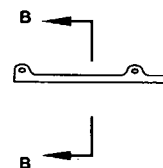
D3508-11F FLAT PATTERN



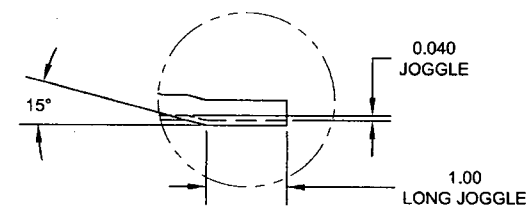
D3508-13F FLAT PATTERN



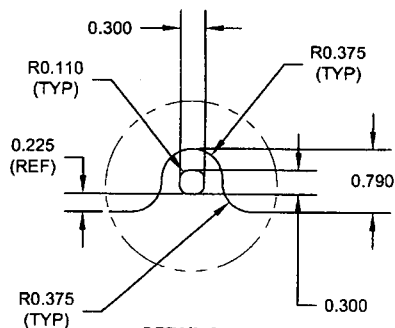
D3508-11 BENDING DETAIL
(MAKE FROM D3508-11F)



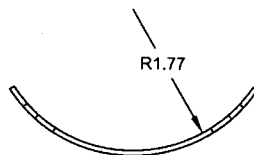
D3508-13 BENDING DETAIL
(MAKE FROM D3508-13F)



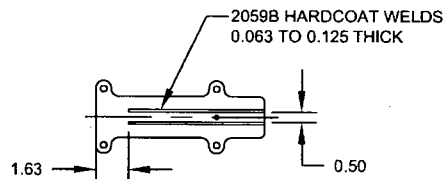
DETAIL C
(SCALE 1:2)



DETAIL A
(SCALE 2:3)



SECTION B-B
(SCALE 2:3)



D3508-13 WELDING DETAIL

RELEASED
07-11-16

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	PH	PORT HADLOCK, WA	
CHECKED	PH	DRAWING NO.	REV. C
MFG. APPR.	PH	D3508	SHEET 2 OF 2
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARPLATE	1:6
DATE	07.04.20	<small>COPYRIGHT © 2007 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC</small>	

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